

Work Order ID 79193-1

79193

Page 1

January-23-12 1:04:18 PM

Item ID: D2661-1

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 23/01/2012 Start Qty: 10.00 *10*

Cust Item ID:

Required Date: 06/02/2012 Req'd Qty: 10.00 *10*

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/01/23 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2661	Rev E

100	HAAS CNC VERTICAL MACHINING #1	0.00							
-----	--------------------------------	------	--	--	--	--	--	--	--

100

HAAS I

HAAS CNC vertical machine #1

Memo

Program part number and batch number.

Program part number and batch number

MACHINE AS PER DWG AND FOLIO FB073

FOLIO REV: AA

DWG REV: E

110	CONVENTIONAL MILLING MACHINE	0.00							
-----	------------------------------	------	--	--	--	--	--	--	--

110

Mill Conv

Conventional Milling Machine

Memo

Machine Keyway and inspect per attached dimension sheet

Work Order ID 79193

79193

Page 2

January-23-12 1:04:18 PM

Item ID: D2661-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Saddle, LH Fwd Aft Out 206
 Start Date: 23/01/2012 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 06/02/2012 Req'd Qty: 10.00 *10* Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00	B.A	12/02/21		6	φ		
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	J.M		12-02-20		6	φ	
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				6Xφ	M/12/02/21		

Work Order ID 79193

79193

Page 3

January-23-12 1:04:18 PM

Item ID: D2661-1 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Saddle, LH Fwd Aft Out 206
 Start Date: 23/01/2012 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 06/02/2012 Req'd Qty: 10.00 *10* Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
150									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 10:30								
	FINISH TIME: 11:00								
	3200								
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: 435	0.00							
170									
Packaging	Memo	0.00							
Packaging									

6 Box of M-L 12/02/21

6 Box 12221

12/21/21

Work Order ID 79193

January-23-12 1:04:18 PM

79193

Page 4

Item ID: D2661-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Saddle, LH Fwd Aft Out 206

Stop ***NS2***

Start Date: 23/01/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 06/02/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/2/21

ME
12-02-21

Picklist Print

January-23-12 1:04:38 PM

Page 1

Work Order ID: 79193

79193

Parent Item: D2661-1

D2661-1

Parent Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 23/01/2012

Required Date: 06/02/2012

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP: C00.11.01Removed P/O for Powder Coat - in house
processEC

IPP REV:D

REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD

IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003		Manufactured	No			100	Each	20.0000	1	10			

D6101-003

Saddle Billet, 7075

**

12-02-17

Location

Loc Qty

Loc Code

MAT040

26

73775

2

73780

7

77562

10

MAT042

-7

MAT044

1

73769

1

79587

10

DART AEROSPACE LTD		Work Order:	79193
Description: 206 Saddle, Outboard, Left side		Part Number:	D2661-1
Inspection Dwg: D2661	Rev: E	DSK:	Rev:
			Page 1 of 2

FIRST ARTICLE INSPECTION DIMENSION SHEET

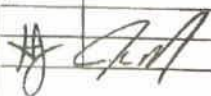
Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		.257	.257	.257	.257	.257
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	1.357	1.367		1.362	1.362	1.362	1.362	1.362
G	0.100	0.140		.120	.119	.120	.120	.120
H	0.210	0.230		.224	.222	.223	.222	.222
I	0.615	0.685		.685	.685	.685	.685	.685
J	2.470	2.510		2.490	2.490	2.490	2.490	2.490
K	1.313	1.343		1.326	1.325	1.325	1.325	1.325
L	0.178	0.198		.188	.188	.188	.188	.188
M	0.470	0.530		.500	.500	.500	.500	.500
N	1.125	1.145		1.136	1.135	1.135	1.135	1.135
O	0.100	0.180		.135	.135	.135	.135	.135
P	0.100	0.140		.128	.128	.129	.128	.128
Q	0.240	0.260		.251	.251	.250	.250	.250
R	0.677	0.697		.687	.687	.687	.687	.687
S	0.100	0.140		.120	.121	.119	.120	.121
T	1.565	1.585		1.576	1.575	1.575	1.575	1.575
U	0.540	0.560		.551	.550	.550	.550	.550
V	0.912	0.932		.922	.922	.921	.922	.921
W	0.787	0.807		.797	.797	.797	.797	.798
X	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Y	4.995	5.005		5.000	5.000	5.000	5.000	5.000
Z	0.490	0.510		.500	.500	.498	.497	.501
AA	0.312	0.319		.313	.313	.313	.313	.313
AB	0.990	1.010		1.000	1.000	1.000	1.000	1.000
AC	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AD	0.490	0.510		.500	.500	.501	.500	.500
AE	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AF	0.235	0.240		.237	.237	.237	.237	.237
AG	0.510	0.515		.512	.512	.512	.512	.512
AH	0.100	0.120		.110	.110	.110	.110	.110
AI								

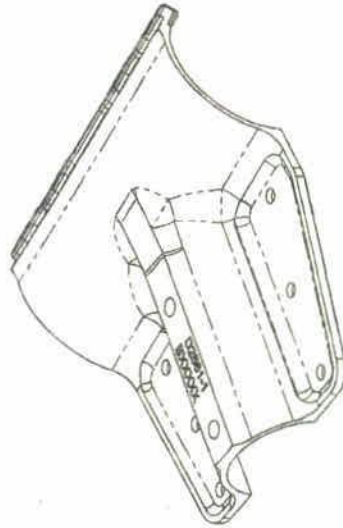
DART AEROSPACE LTD		Work Order:	79193
Description: 206 Saddle, Outboard, Left side		Part Number:	D2661-1
Inspection Dwg: D2661 Rev: E DSK: Rev:		Page 2 of 2	

FIRST ARTICLE INSPECTION DIMENSION SHEET

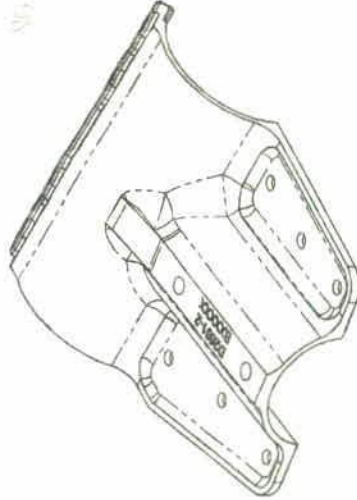
Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
AJ								
AK								
AL								
AM								
AN								
Accept/Reject								

Measured by:		Date:	12-02-19
Audited by:		Date:	12-02-20
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	



D2661-1 SADDLE, OUTSIDE, LH



D2661-2 SADDLE, OUTSIDE, RH

RELEASED
2011-11-16

REV.	DESCRIPTION	DATE
E	REDRAW & REFORMAT DWG. 0.887 WAS 0.547 (05-2,08-4), REF NCR 11-035	11.10.31
D	RD.183 WAS RD.30; 0.0.310 WAS 0.0.313	06.11.08
C	INCORPORATE DEC 9122, #102, 0095	06.05.20
B	ANGLE AND NOTES ADDED	07.07.11
A	NEW ISSUE	07.03.25
DESIGN	BY	DATE
DRAWN	W	
CHECKED	W	
MFG. APPR.	ASS	
APPROVED	W	
DE APPR.	W	
DATE	11.10.31	
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D2661-1 SADDLE, OUTSIDE, LH

1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D6101-003 SADDLE BILLET

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3

3) TOLERANCES: PER DART QSI 016 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
IDENTIFY WITH DART LOGO PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.015 WITH MIN RADIUS OF 0.25

7) WEIGHT: 0.79 lbs

RELEASED
2011-11-16

DESIGN	g	DART AEROSPACE USA, INC. KENT, WA
DRAWN	g	
CHECKED	ASS	DRAWING NO. D2661
MFG. APPR.	SW	REV. E SHEET 2 OF 5
APPROVED	SW	TITLE SADDLE, OUTSIDE
DE APPR.	SW	SCALE NTS
DATE	11.10.31	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DRAWING IS A PROPRIETARY CONFIDENTIAL, AND IS SUPPLIED BY THE DART AEROSPACE USA, INC. AND IS NOT TO BE REPRODUCED OR COPIED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.

RELEASE
2011-11-16

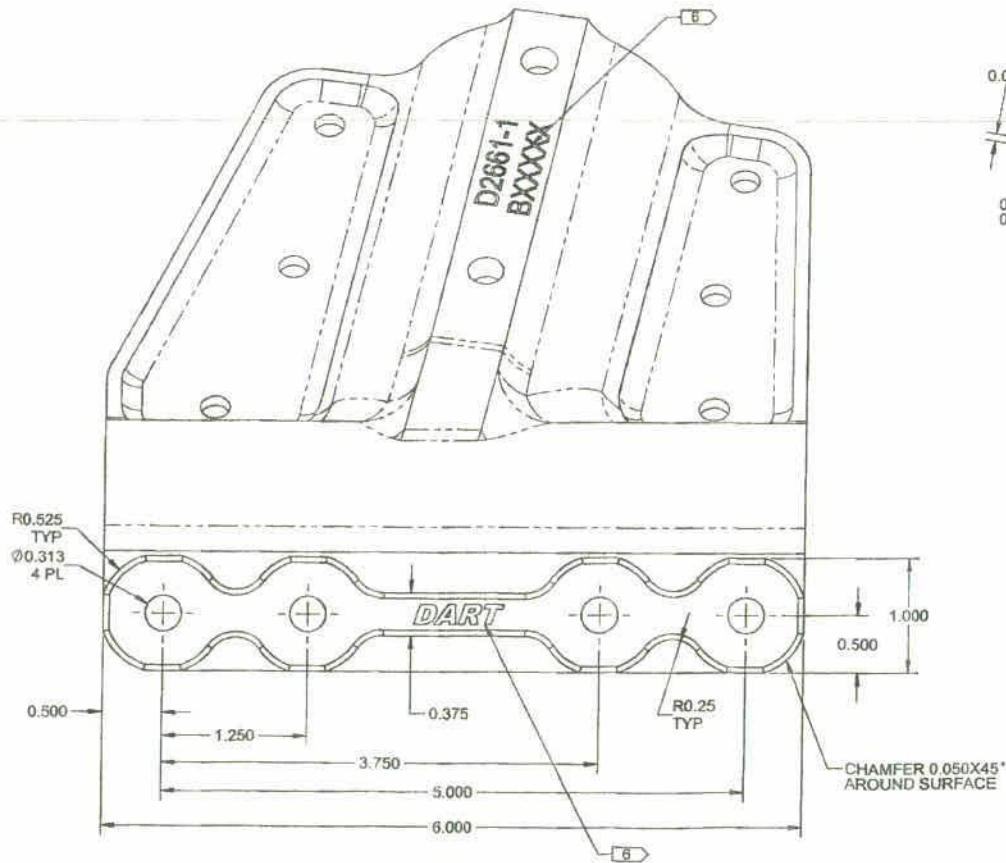
CHAMFER 0.050X45°
AROUND SURFACE
2PL



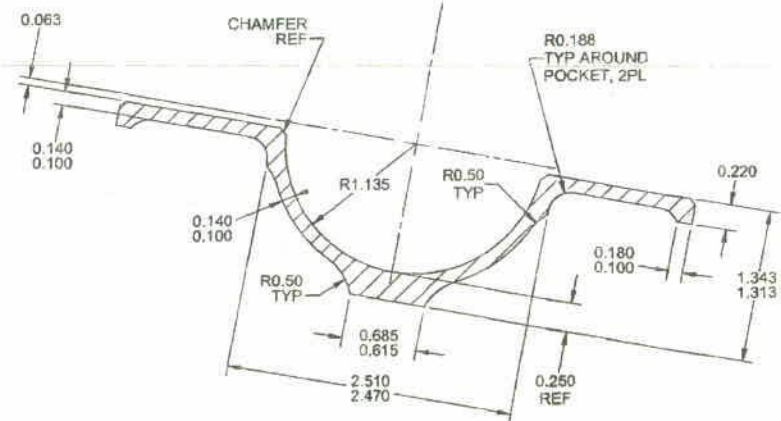
2) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
IDENTIFY WITH DART LOGO PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.015 WITH MIN RADIUS OF 0.25
7) WEIGHT: 0.79 lbs

DESIGN	g	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.		D2661	SHEET 4 OF 9
APPROVED		TITLE	SCALE
DE APPR.		SADDLE, OUTSIDE	NTS
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79193



VIEW B-B
SCALE 1.5X
VIEW ROTATED

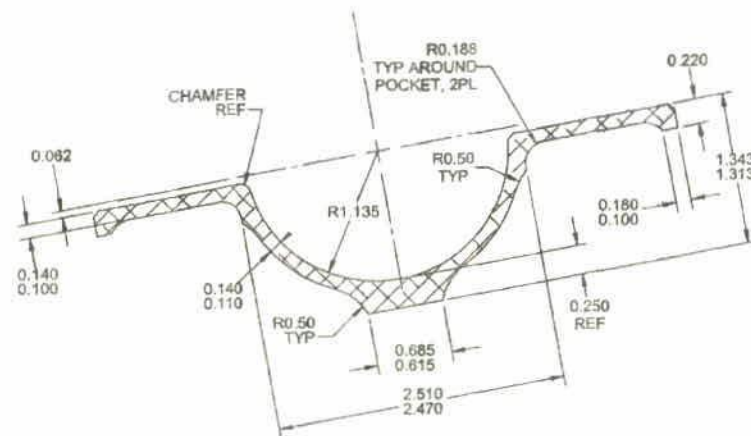
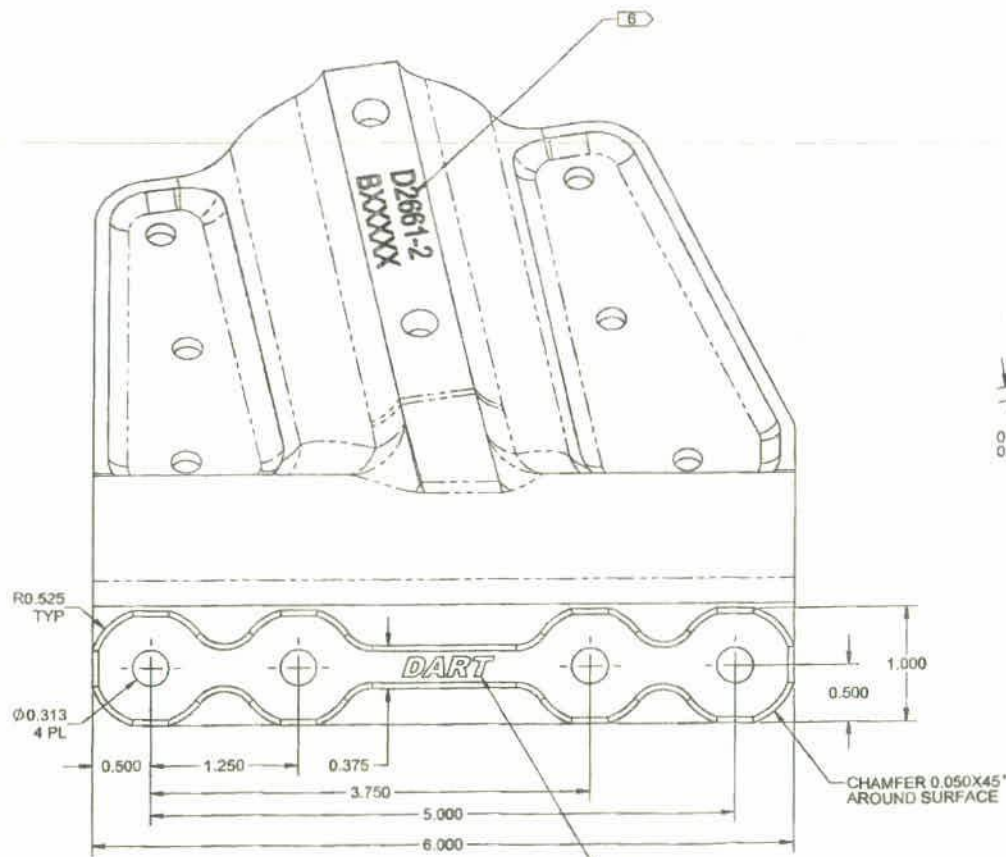


VIEW A-A
SCALE 1.5X

RELEASED
2011-11-16

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO. D2661	REV. E
MFG. APPR.		TITLE	SHEET 3 OF 5
APPROVED		SADDLE, OUTSIDE	SCALE
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79193



2011-11-16

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.		D2661	SHEET 5 OF 5
APPROVED		TITLE	SCALE
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DART AEROSPACE LTD				Work Order: 79193	
Description: 206 Saddle, Outboard, Left side				Part Number: D2661-1	
Inspection Dwg: D2661 Rev: E DSK: Rev:				Page 1 of 2	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	# 6	2	3	4	5
A	3.611	3.621		3.616				
B	0.256	0.263		0.257				
C	0.315	0.322		0.316				
D	2.495	2.505		2.500				
E	1.674	1.684		1.679				
F	1.357	1.367		1.362				
G	0.100	0.140		0.120				
H	0.210	0.230		0.222				
I	0.615	0.685		0.685				
J	2.470	2.510		2.490				
K	1.313	1.343		1.325				
L	0.178	0.198		0.188				
M	0.470	0.530		0.500				
N	1.125	1.145		1.135				
O	0.100	0.180		0.135				
P	0.100	0.140		0.129				
Q	0.240	0.260		0.250				
R	0.677	0.697		0.687				
S	0.100	0.140		0.118				
T	1.565	1.585		1.575				
U	0.540	0.560		0.550				
V	0.912	0.932		0.920				
W	0.787	0.807		0.799				
X	5.990	6.010		6.000				
Y	4.995	5.005		5.000				
Z	0.490	0.510		0.499				
AA	0.312	0.319		0.313				
AB	0.990	1.010		1.000				
AC	1.245	1.255		1.250				
AD	0.490	0.510		0.500				
AE	3.745	3.755		3.750				
AF	0.235	0.240		0.237				
AG	0.510	0.515		0.512				
AH	0.100	0.120		0.110				
AI								

DART AEROSPACE LTD		Work Order: 79193
Description: 206 Saddle, Outboard, Left side		Part Number: D2661-1
Inspection Dwg: D2661 Rev: E DSK: Rev:		Page 2 of 2

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
AJ								
AK								
AL								
AM								
AN								
Accept/Reject								

Measured by: Ba	Date: 12/02/19
Audited by: [Signature]	Date: 12-02-20
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	[Signature]